

Date: Wednesday, 15/10/2008 3:14:52 PM
 User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LOWER DOUBLER
Job Number : 42609	
Estimate Number : 12808	
P.O. Number :	Part Number : D36081
This Issue : 15/10/2008 S.O. No. :	Drawing Number : D3608 PRELIM
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL / MED FAB	Drawing Revision : PRELIM
Previous Run : 31510	Material :
Written By :	Due Date : 22/10/2008 Qty: 2 Um: Each
Checked & Approved By : <u>UMF 08-10-15</u>	
Comment : Est Rev:A New Issue 07-03-26 JLM Est Rev:B 08-10-15 preliminary issue DD verified by:EC	

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M304S22GA

304/316 .032 Sheet



Comment: Qty.: 0.7762 sf(s)/Unit Total: 1.5523 sf(s)

304/316 .032 Sheet

Batch: 109087 IB 8-10-16

mzt'l certs req'd (Chantal)

2.0

WATER JET 109057

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3608

Dwg Rev: PRE IB 8-10-16Prog Rev: Lfm

2-Deburr if necessary

IB 8-10-16

②

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IB 8-10-16

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

IB 08-10-17

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1- deburr if necessary

2- Bend as per Dwg D3608

IB08-10-17

Date: Wednesday, 15/10/2008 3:14:52 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LOWER DOUBLER

Job Number: 42609

Part Number: D36081

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

60816/17 (18)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



POSITIVE RECALL

EFFECTIVE

8.10.06

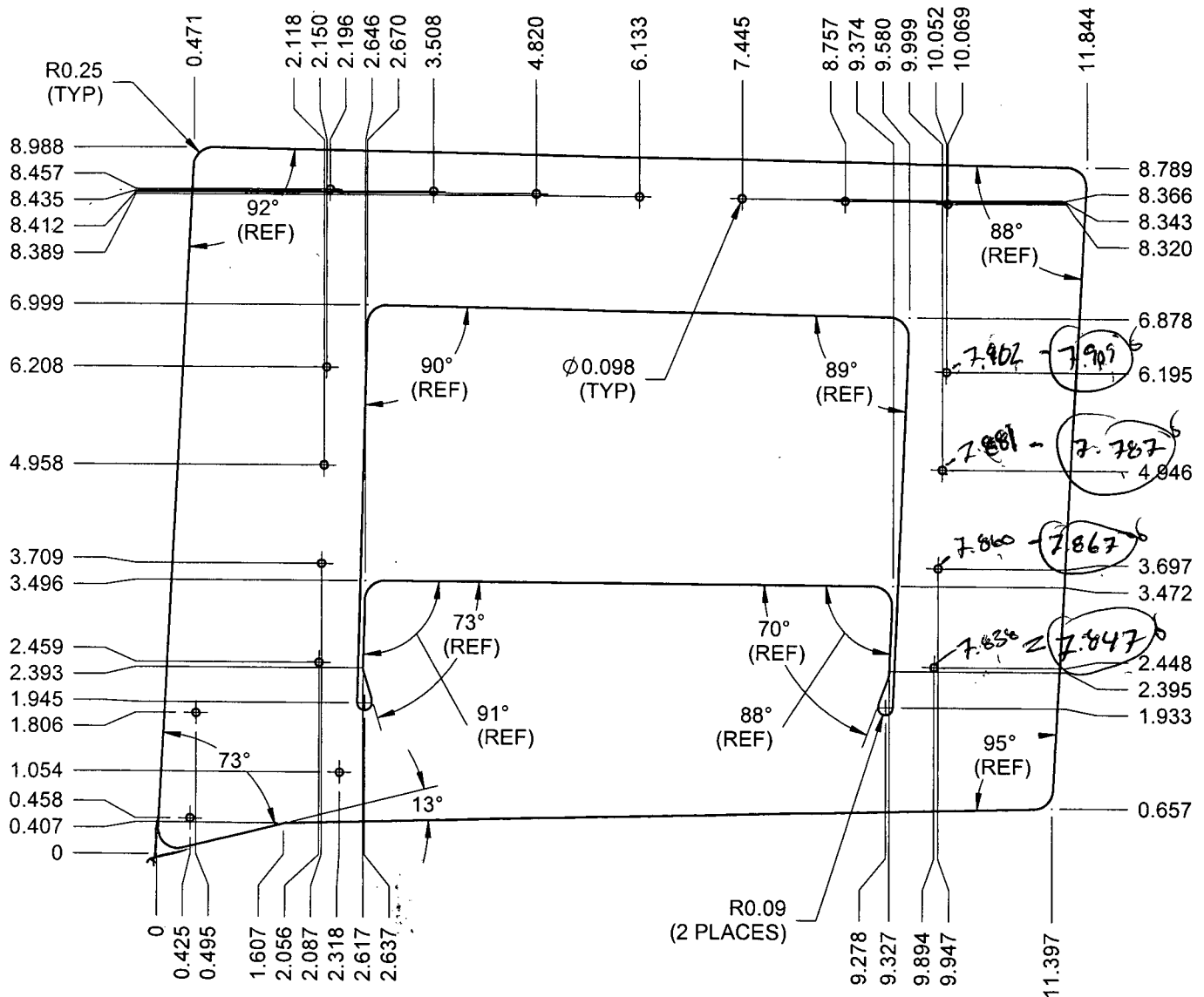
AUTH

u

RELEASED

DATE

DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED	DRAWING NO. D3608	REV. A SHEET 2 OF 3
DATE 07.04.11	TITLE DOUBLER		SCALE 1:2



D3608-1F LOWER DOUBLER

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 22 GAUGE
PER AMS 5513 OR AMS 5524 (REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

PRELIMINARY ISSUE

MP 08/14/15

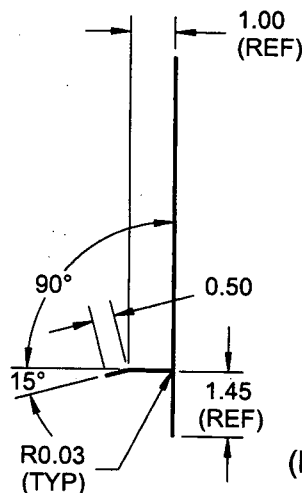
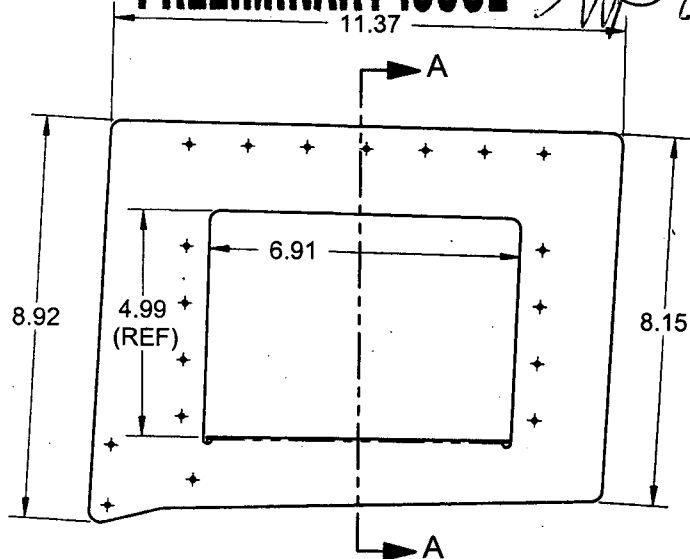
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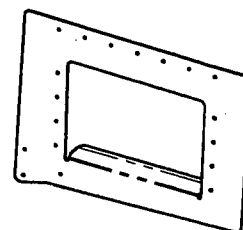
DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED	DRAWING NO. D3608	REV. A
DATE 07.04.11		TITLE DOUBLER	SHEET 1 OF 3
REV A	DATE 07.04.11	DESCRIPTION NEW ISSUE	SCALE 1:4

PRELIMINARY ISSUE

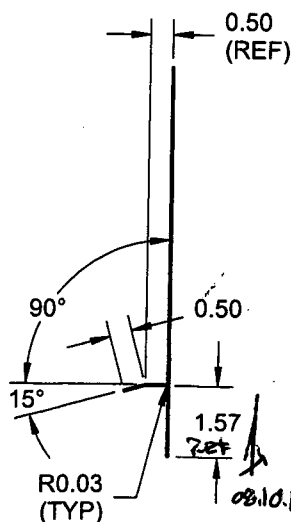
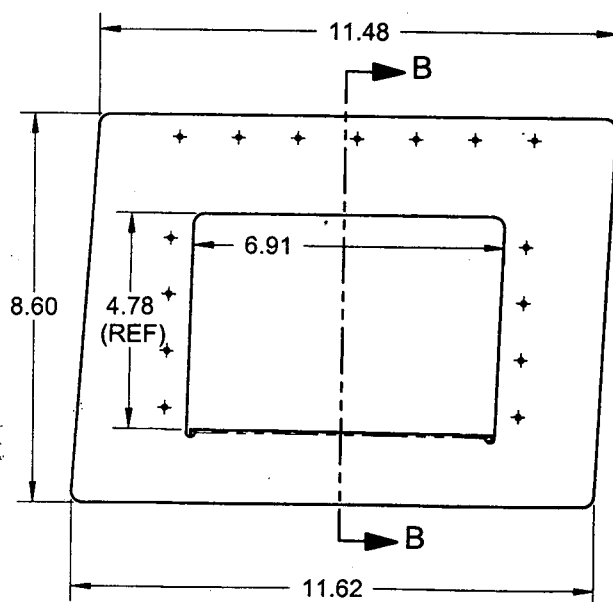
MP 06/19/15



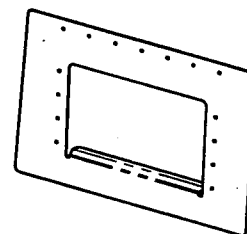
SECTION A-A



D3608-1 LOWER DOUBLER
(MAKE FROM D3608-1F)



SECTION B-B



D3608-3 UPPER DOUBLER
(MAKE FROM D3608-3F)

NOTES:

- 1) FINISH: NONE
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) IDENTIFY WITH DART P/N D3608-1 OR D3608-3 USING FINE POINT PERMANENT INK MARKER
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

Product #: D412-775

Job #: 00264

Date: 08.10.15

Product Name: PROTECTIVE TRIMS

Requested By: DS

Design Manager Approval: _____

Quantity	Part Number	Category	Description	Drawing Date	Material Cert Req'd?	Due Date	Comments	Date Completed
2	D3608-1F	WJ	LOWER DOUBLER (FLAT PATTERN)	08.10.15	YES**		REQUIRED FOR FIT, FORM AND FUNCTION.*	
12	D3608-1F	GA	LOWER DOUBLER	08.10.15	PER -1F ABOVE		REQUIRED FOR FIT, FORM AND FUNCTION.*	
2	D3608-3F	WJ	UPPER DOUBLER (FLAT PATTERN)	08.10.15	YES**		REQUIRED FOR FIT, FORM AND FUNCTION.*	
12	D3608-3F	GA	UPPER DOUBLER	08.10.15	PER -3F ABOVE		REQUIRED FOR FIT, FORM AND FUNCTION.*	
							CONFORMITY IS MANDATORY.	

DART AEROSPACE LTD		Work Order: 42609
Description: LOWER DOUBLER		Part Number: D3608-1
Inspection Dwg: D3608-1, Rev: PRELIM		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article

☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	+ .004 - .001	.101	X			
.458	+/- .010	.452	X			
1.054	+/- .010	1.052	X			
1.806	+/- .010	1.794	X			
2.459	+/- .010	2.455	X			
3.496	+/- .010	3.491	X			
3.709	+/- .010	3.710	X			
4.958	+/- .010	4.954	X			
6.208	+/- .010	6.209	X			
6.999	+/- .010	6.992	X			
8.889	+/- .010	8.883	X			
8.412	+/- .010	8.408	X			
8.435	+/- .010	8.429	X			
8.457	+/- .010	8.451	X			
8.988	+/- .010	8.982	X			
.471	+/- .010	.468	X			
2.118	+/- .010	2.112	X			
2.150	+/- .010	2.146	X			
2.196	+/- .010	2.192	X			
2.646	+/- .010	2.640	X			
3.508	+/- .010	3.501	X			
4.820	+/- .010	4.816	X			
6.133	+/- .010	6.128	X			

Measured by: RB
Date: 8-10-16

Audited by: [Signature]
Date: 08.10.17

Prototype Approval: [Signature]
Date: 08/10/17

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD		Work Order:
Description:		Part Number:
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
7.445	+/- .010	7.440	x			
8.757	+/- .010	8.755	x			
9.586	+/- .010	9.578	x			
9.999	+/- .010	9.995	x			
10.052	+/- .010	10.047	x			
10.069	+/- .010	10.064	x			
2.448	+/- .010	2.442	x			
3.472	+/- .010	3.468	x			
3.697	+/- .010	3.694	x			
4.946	+/- .010	4.941	x			
6.195	+/- .010	6.189	x			
6.878	+/- .010	6.872	x			
8.320	+/- .010	8.317	x			
8.343	+/- .010	8.337	x			
8.366	+/- .010	8.360	x			
8.789	+/- .010	8.786	x			

Measured by:	RB
Date:	8-10-17

Audited by:	L
Date:	08.10.17

Prototype Approval:	MP
Date:	08.10.17

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	